

Work Order ID 70454

Wednesday, June 08, 2011 3:35:47 PM



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Item ID:	D3021-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Tube Assembly				Stop	
Start Date:	6/8/2011	Start Qty:	1.00			
Required Date:	6/10/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	<u>MK</u>	Date:	<u>11-06-08</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3021	Rev A								

100	Large Fab	0.00							
	Large Fab	Memo							
Large Fab	1-Cut tube as per Dwg D3021	0.00							
	2-Drill tube as per Dwg D3021 using D8622								
	3-Deburr								
	4-Weld as per Dwg D3021 QSI004								
	A/R 4130 Rod Batch: <u>M10075</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC	Memo							
Quality Control									

12 11-6-10 (22)

1 0 8E11/06/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Work Order ID 70454

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Item ID: D3021-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 6/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

w/o 70005

0.00

Packaging

EB 4/06/13 ①

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/14
ME
11-06-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 70454

Parent Item: D3021-041

Parent Item Name: Tube Assembly

Start Date: 6/8/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP 01.10.23 New Issue SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3017-11		Manufactured	No			100	Each	24.0000	2	2			
													
cap													

Location Loc Qty Loc Code

WA 24
69074 24

M4130NT0.750W.049		Purchased	No			100	f	100.0990	2.0833	2.192947			
													
4130 RD Tube .750 x.049W													

Location Loc Qty Loc Code

MAT033 100.099
117691 1.129
117973 46.97
52

2.08

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

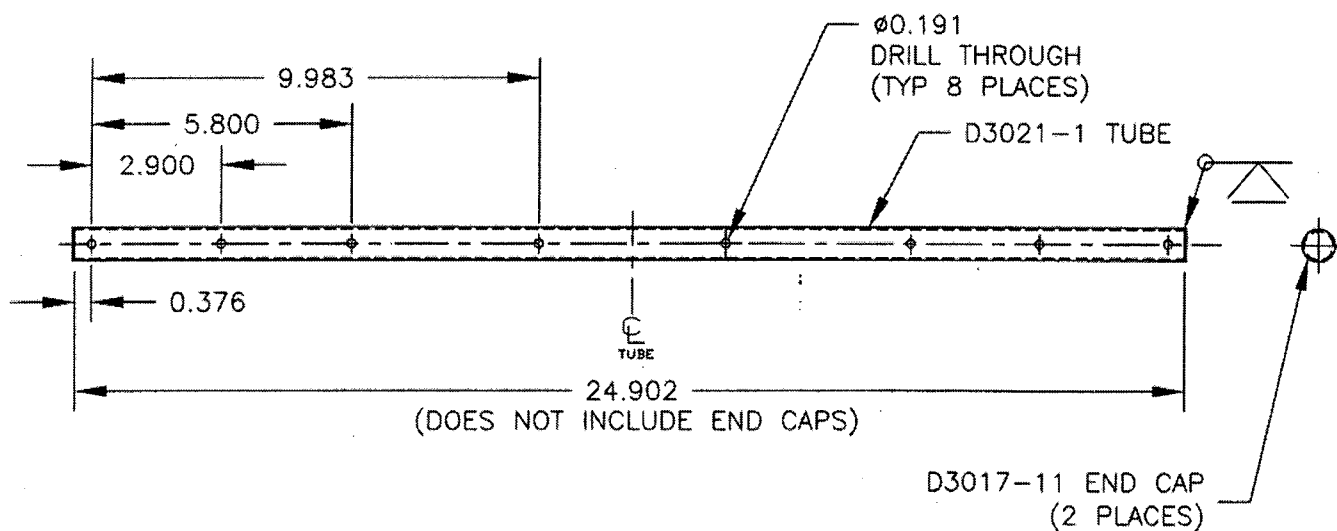
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

70452



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\phi 0.75$ DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.309

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